

Work Order ID 87797

87797

Page 1

July-12-12 9:02:26 AM

Item ID: D105-674-011G

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2966	Rev A2

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D105-674-011G

CHG002

DAS 16 2-9 12/25/12

12-7-25

130

0.00

130

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

** Pull D2966-1 bent **

1-Cut Aft end at 107.06" using DT8185D

2-Deburr ends

3-Drill Aft Cap holes using DT8678

4-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.

5-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.

6-Open Aft Cap holes using #6 drill

7-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.

8-Deburr holes.

9-Open remaining (16) crossbolt holes to Ø

①

SAD 12-07-12

B87797

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Skidtubes	0.00							
140									
Skidtubes	Memo	0.00							
Skidtubes	1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole. 2-Grind Fwd Cap welds flush								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

A/R 11/20/16
BE 12/07/16
SAD 12-07-16

DAS 16 9-83 12/07/16

DAS 16 9-83 12/07/16

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									
180	QC7-Inspect Chemical Conversion Coat	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Skidtubes	0.00							
190									
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to finish size as per Dwg D2966 2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966 3-Deburr holes inside & outside, blow out chips								

8036

DP 12-7-17

DL 12/07/12

Dart Aerospace Ltd

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

0.00

Skidtubes

Memo

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

A/R Sikaflex-291 batch: 122130Sikaflex expiry date: 13-3-14start time: 16:30end time: 12-07-1912/07/18

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

A/R Aluminum Rod batch: m120164BE 12/07/19

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

4-Grind welds flush as per Dwg D2966

DP 12-7-19

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

DAS 16 9-5 12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Required Date: 7/20/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
220									
QC	Memo	0.00							
Quality Control									
225	Touch up alodine	0.00							
225									
HandFinish	Memo	0.00							
Hand Finishing									
226	Assemble as per dwg	0.00							
226									
HandFinish	Memo	0.00							
Hand Finishing	✓ INSTALL ALS7-1032-130, MS27039-1-08, AN960JD10L IN TWO PLACES BEFORE POWDERCOATING								

DAS
16
8-22 7/26/19

1X ~~Ø~~ M-F 12/07/19

1X ~~Ø~~ M 12/07/19

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				1X	0		mt 12/07/12
230									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 2:00	0.00							
	OVEN TEMPERATURE: 320 F								
	FINISH TIME: 2:30								
240	QC3- Inspect Part Finish	0.00				1X	0		12/07/12
240									
QC									
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	HandFinishing	0.00							
250	HandFinish	0.00				1 x	6	94-1104123	
Hand Finishing	Memo								
	1-Inspect for foreign objects as per QSI 024								
	2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.								
	Pick:								
	QtyPart NumberDescriptionBatch								
	A/RSikaflex-291 11121531								
	Sikaflex expiry date: 12/08								
	3-Wing Walk as per Dwg D2966 and QSI 005 4.4								
	Batch: _____								
260	QC3- Inspect Part Finish	0.00							
260	QC	0.00							
Quality Control	Memo								

1x 6 94-11-01-23

DAS
16 17/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

QC5- Inspect part completeness to step on W/O

0.00

270

QC

Memo

0.00

Quality Control

*****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966*****

280

Pick Kit

0.00

280

Packaging

Memo

0.00

Packaging

290

QC4- 100% Inspect kits for completeness

0.00

290

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D105-674-011G Location: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

6/12/12/200

12/7/30

*MUF
12-07-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

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Parent Item: D105-674-011G
Parent Item Name: Skidtube, Grey

Start Date: 7/12/12
Start Qty: 1.00

Required Date: 7/20/12
Required Qty: 1.00

Comments: IPP Rev:A04.07.07New IssueKJ/JLM IPP Rev:B 10.06.09 remove seq110 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2966-1-BENT Skidtube Assembly 105		Manufactured	No			130	Each	2.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		2							
				83295		1							
				83783		1							
D2964 Cap		Manufactured	No			140	Each	29.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		12							
				83064		12							
				LG002		17							
				74719		17							
D2976 BO 105 Skidtube I Beam		Manufactured	No			200	Each	0.0000	1				
D2971 Cross Bolt Spacer		Manufactured	No			200	Each	22.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		22							
				74720		22							
D2973 Cross Bolt Spacer		Manufactured	No			200	Each	64.0000	7	7			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		64							
				14636		14							
				80092		50							

SAD 1207/12

BE 12/07/10

PL 12/07/18
BE 12/07/19

BE 12/07/19

7

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Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

D2965
Cap, 105 Skidtube

*

Manufactured No

250 Each 44.0000

1387959 (x1) 1 11 11/07/12

Location

Loc Qty

Loc Code

FP002

44

71371

4

80089

40

D2970-1
Wearplate

Manufactured No

250 Each 8.0000

1 11 11/07/12

Location

Loc Qty

Loc Code

FP001

8

48213

3

80090

5

D2970-3
Wearplate

Manufactured No

250 Each 9.0000

1 11 11/07/12

Location

Loc Qty

Loc Code

FP001

1

48214

1

FP002

8

80091

8

D3176-1
Bushing

Manufactured No

250 Each 6.0000

1 (x1) 1 11 11/07/12

Location

Loc Qty

Loc Code

ST032

6

37586

6

D3176-3
Nut

Manufactured No

250 Each 9.0000

1 11 11/07/12

Location

Loc Qty

Loc Code

ST032

9

44896

9

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Shop Packet Print

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Dart Aerospace Ltd

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Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

250

Each

1,520.0000

36

Insert

Location

Loc Qty

Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

1469

119530

73

120181

12

121444

1384

36 36 11/07/12

MS27039-1-08

Purchased

No

250

Each

1,168.0000

26

Screw

Location

Loc Qty

Loc Code

ST291

1168

117423

81

119075

1

120308

166

121011

43

121243

500

121708

377

x26

26 26 11/07/12

AN960JD10L

NAS1149D0332J

Purchased

No

250

Each

0.0000

28

Washer

X

11121011

(x28) 28 28 11/07/12

MS27039-1-09

Purchased

No

250

Each

267.0000

2

Screw

Location

Loc Qty

Loc Code

FP002

93

18057

93

ST291

174

111650

174

V2

July-12-12 9:02:26 AM

Shop Packet Print

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Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

S D2972 Bushings	Manufactured	No		290	Each	27.0000	6	6	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			ST022	27						
			33544	4						
			44160	23				44160		
S D2974 Packer	Manufactured	No		290	Each	37.0000	1	1	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			ST022	37						
			71997	37				71997		
S D2975 Wearshoe	Manufactured	No		290	Each	4.0000	2	2	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			ST497A	2						
			74721	2				74721		
			ST500	2						
			80093	2						
S AN4-51A Bolt	Purchased	No		290	Each	526.0000	3	3	JB	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			362	96						
			121181	96						
			ST361	430						
			119798	30						
			122151	400				122151		
S AN960JD10L Washer	Purchased	No		290	Each	0.0000	8	8	JB	12/07/25
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
			NAS1149D0332J					121708		

July-12-12 9:02:26 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 87797

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L4
Nut

Purchased No

290 Each 914.0000

3

3

Location

Loc Qty

Loc Code

ST300

914

119075

116

121011

193

121444

605

121444

MS27039-1-08

Screw

Purchased No

290 Each 1,168.0000

8

8

Location

Loc Qty

Loc Code

ST291

1168

117423

81

119075

1

120308

166

121011

43

121243

500

121708

377

122452 12/07/12

July-12-12 9:02:26 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 *[initials]*

4678



Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



01.01.24
01.01.30

A2	02.10.30	ADD D3176-1/-3	<i>[initials]</i>
A1	01.01.24	CHANGE COLOR TO BLACK SANDTEX	<i>[initials]</i>

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

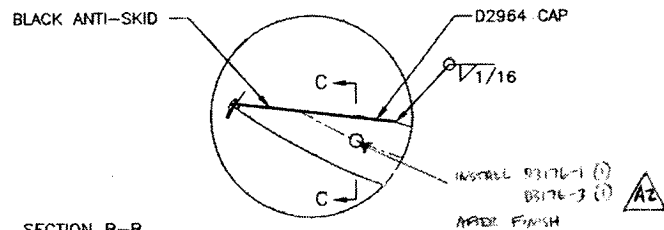
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

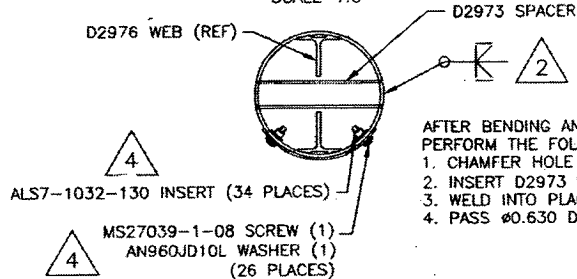
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 1:3

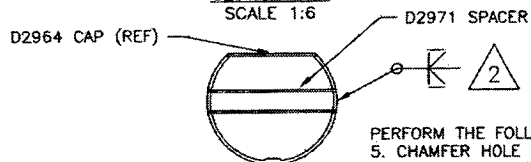


SECTION B-B
SCALE 1:6



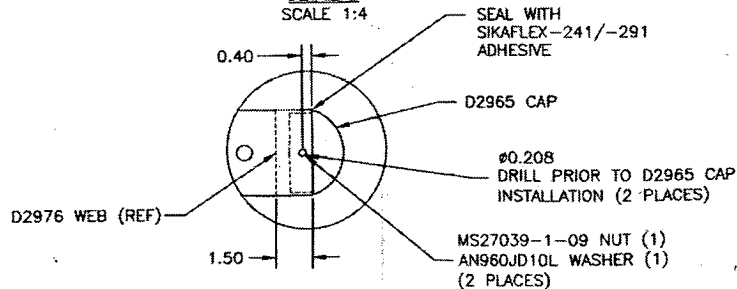
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D2973 SPACER (7 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

SECTION C-C
SCALE 1:6

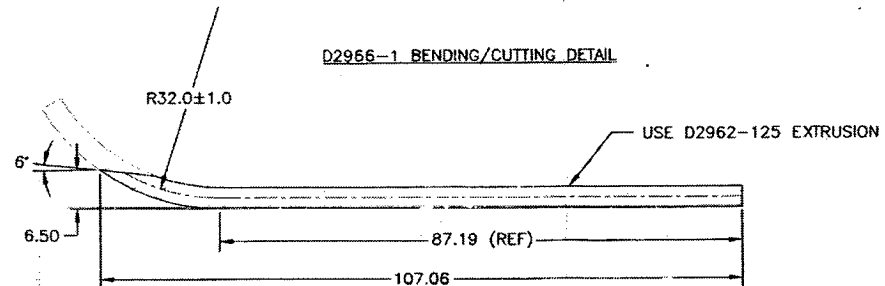


- PERFORM THE FOLLOWING FOR $\phi 0.625$ HOLES ONLY:
5. CHAMFER HOLE $0.030 \times 45^\circ$
 6. INSERT D2971 SPACER
 7. WELD INTO PLACE AND GRIND FLUSH
 8. PASS $\phi 0.484$ DRILL TO REMOVE SPILL OVER

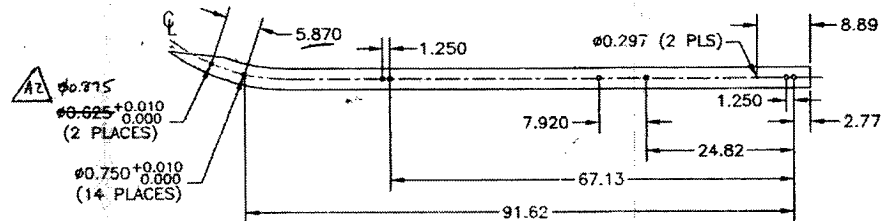
DETAIL D
SCALE 1:4



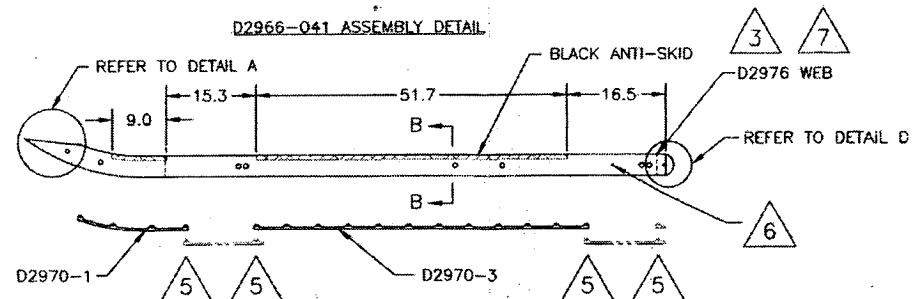
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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DESIGN
RF

CHECKED
A

DATE
00.03.08

DRAWN BY
RF

APPROVED
A

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO.
D2966

TITLE
BO 105 SKIDTUBE ASSEMBLY

REV. A
SHEET 2 OF 2

SCALE
1:20

RELEASED
00.05.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 259

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B68574
Part number: D105-674-0116
Description: 10S
Welding Process: Tig~~M~~ Mig~~[]~~
Base materiel: Aluminum
Current: AC~~[X]~~ DC~~[]~~

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass~~[X]~~ fail~~[]~~
pass~~[X]~~ fail~~[]~~

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass~~[X]~~ fail~~[]~~
pass~~[X]~~ fail~~[]~~
pass~~[X]~~ fail~~[]~~
pass~~[X]~~ fail~~[]~~
pass~~[X]~~ fail~~[]~~
pass~~[X]~~ fail~~[]~~

Qualifier Sal Davis Date of Test Coupon 11.06.30
Welder Barclay Elliott Date of Test Coupon 11.06.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld